

Date: Friday, 9/15/2006 12:02:52 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HANDLE		
Job Number	: 28623					
Estimate Number	: 11208					
P.O. Number	: N/A			Part Number	: D333015	
This Issue	: 9/15/2006		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D3330 REV B1	
First Issue	: N/A		Type	: LARGE FAB ASSY		
Previous Run	: N/A			Project Number	: N/A	
Written By	:			Drawing Revision	: B1	
Checked & Approved By	:			Material	: N/A	
Comment	: Est A 05.01.13 New issue KJ/JLM			Due Date	: 10/5/2006	
				Qty:	6 Um:	
					Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M1018R0375	1010-1025 Steel Bar	
		Comment: Qty.: 0.6999 f(s)/Unit Total : 4.1996 f(s) 1010-1025 Steel Bar	
		Material: AISI 1018-1025 0.375" Round Bar cut 8.00"long. (M1018-R0.375)	
		Identify as D3330-15 Batch: M16634	
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1 Fabricate handle as per Dwg D3330 Deburr	
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: WS	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/09/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/15/2006 12:02:52 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE

Job Number: 28623

Part Number: D333015

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06.09.25

Job Completion



U 06.09.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

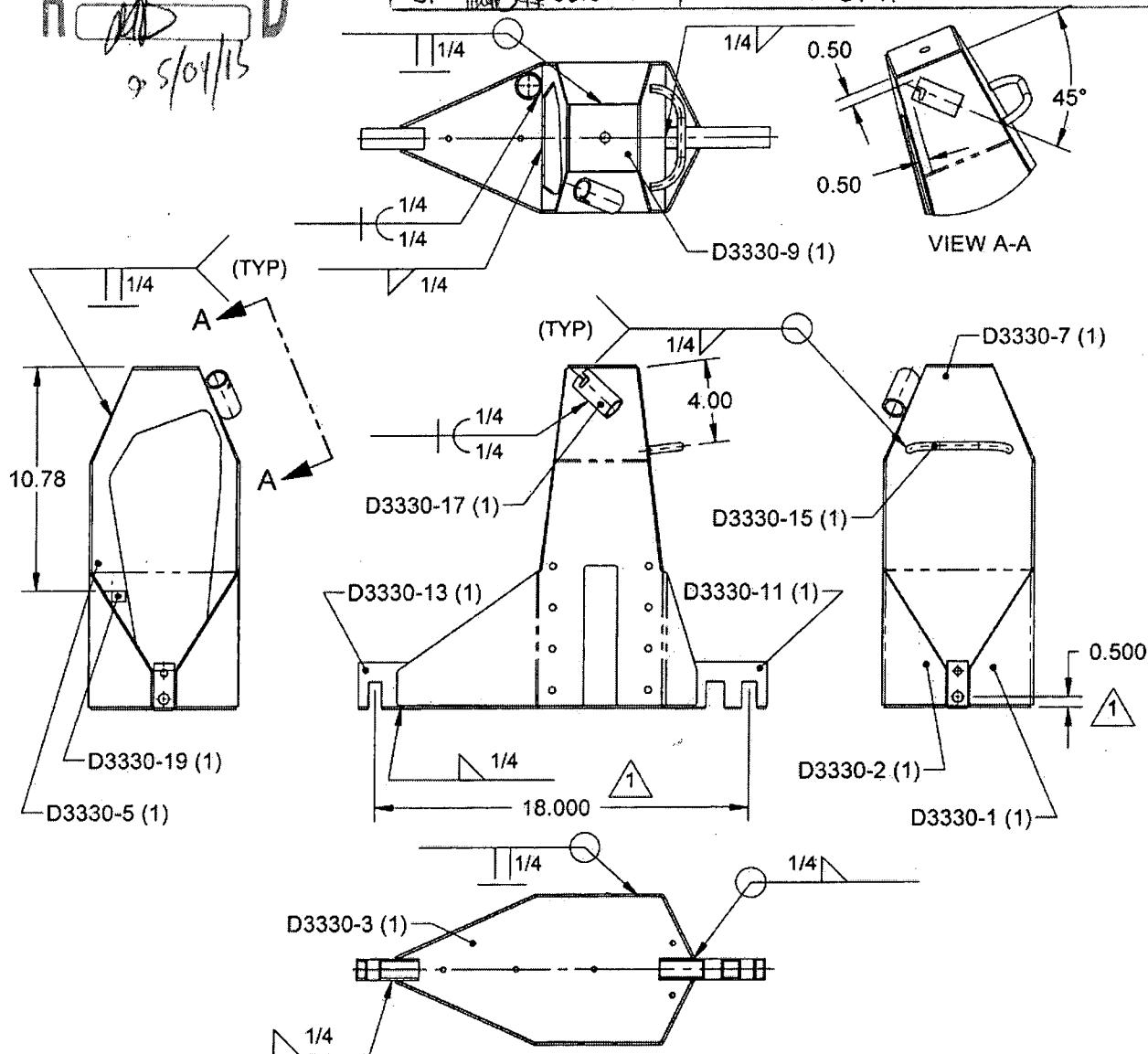
NOTE: Date & initial all entries



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DATE 05.02.26	TITLE FRAME WELDMENT	SCALE 1:8

REV. B
SHEET 1 OF 9

RELEASED
5/01/15



D3330-041 FRAME WELDMENT

NOTES:

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005^{REF TO AMENDMENT}
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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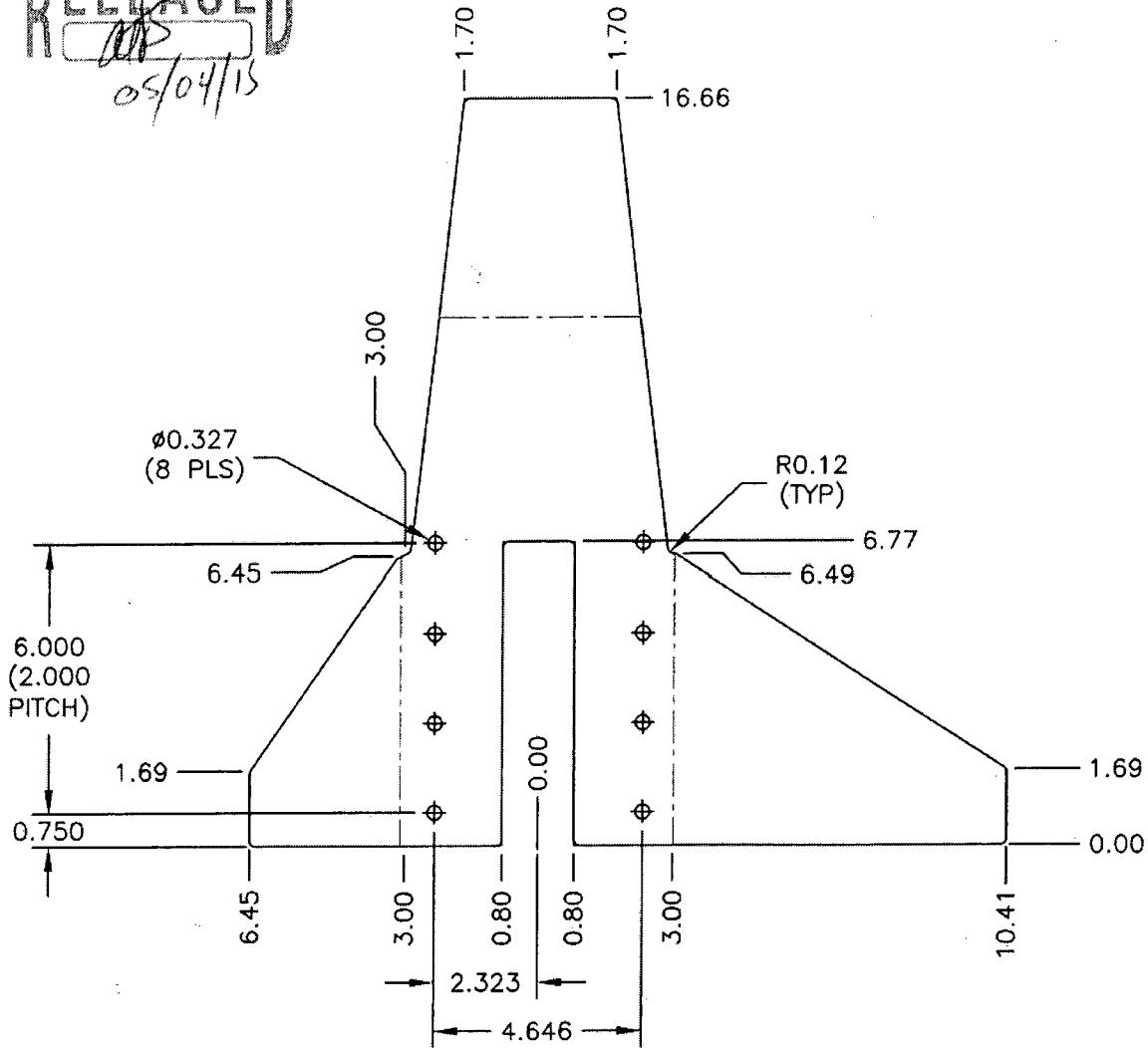
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WORK ORDER
NO. 28623



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DATE 05.02.26	TITLE FRAME WELDMENT	SCALE 1:4	

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05/04/13



D3330-1 PANEL

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NOTES:

NOTES:

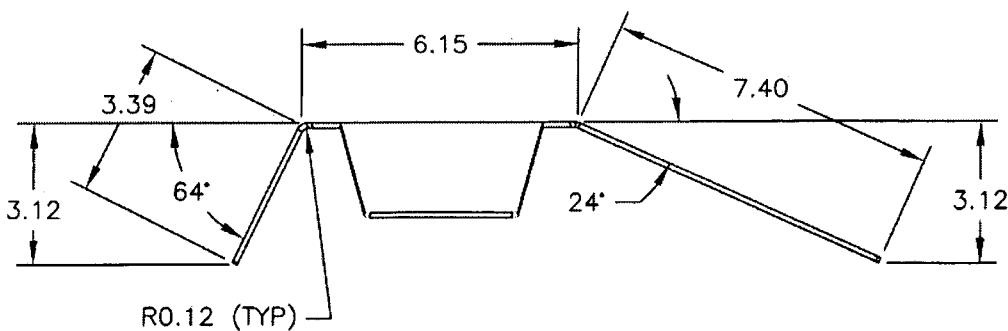
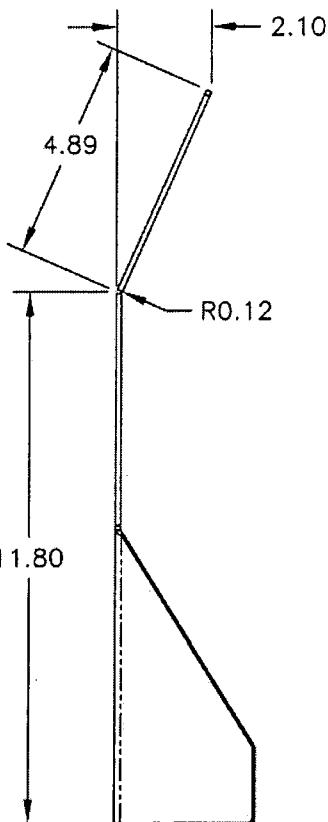
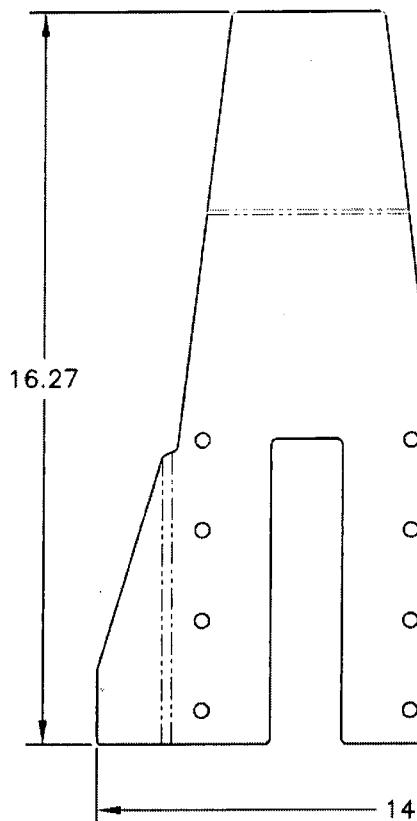
1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 INCONTROLLED COPY
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK) SUBJECT TO AMENDMENT
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED WITHOUT NOTICE
3) ALL DIMENSIONS ARE INCHES WORK ORDER
4) BREAK ALL SHARP EDGES 0.005 TO 0.010 NO. Z8623



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DATE	05.02.26	TITLE	SHEET 3 OF 9

1:4

RELEASED
05/04/15



D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

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WITHOUT NOTICE
WORK ORDER
NO. 28623

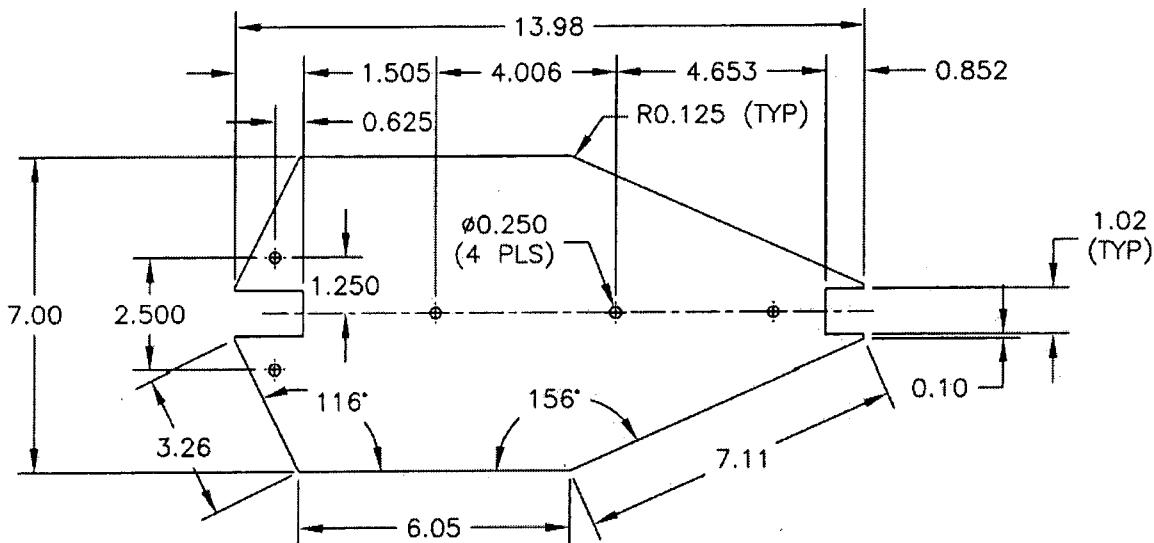
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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:4

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AB
05/04/15

**D3330-3 PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 IN THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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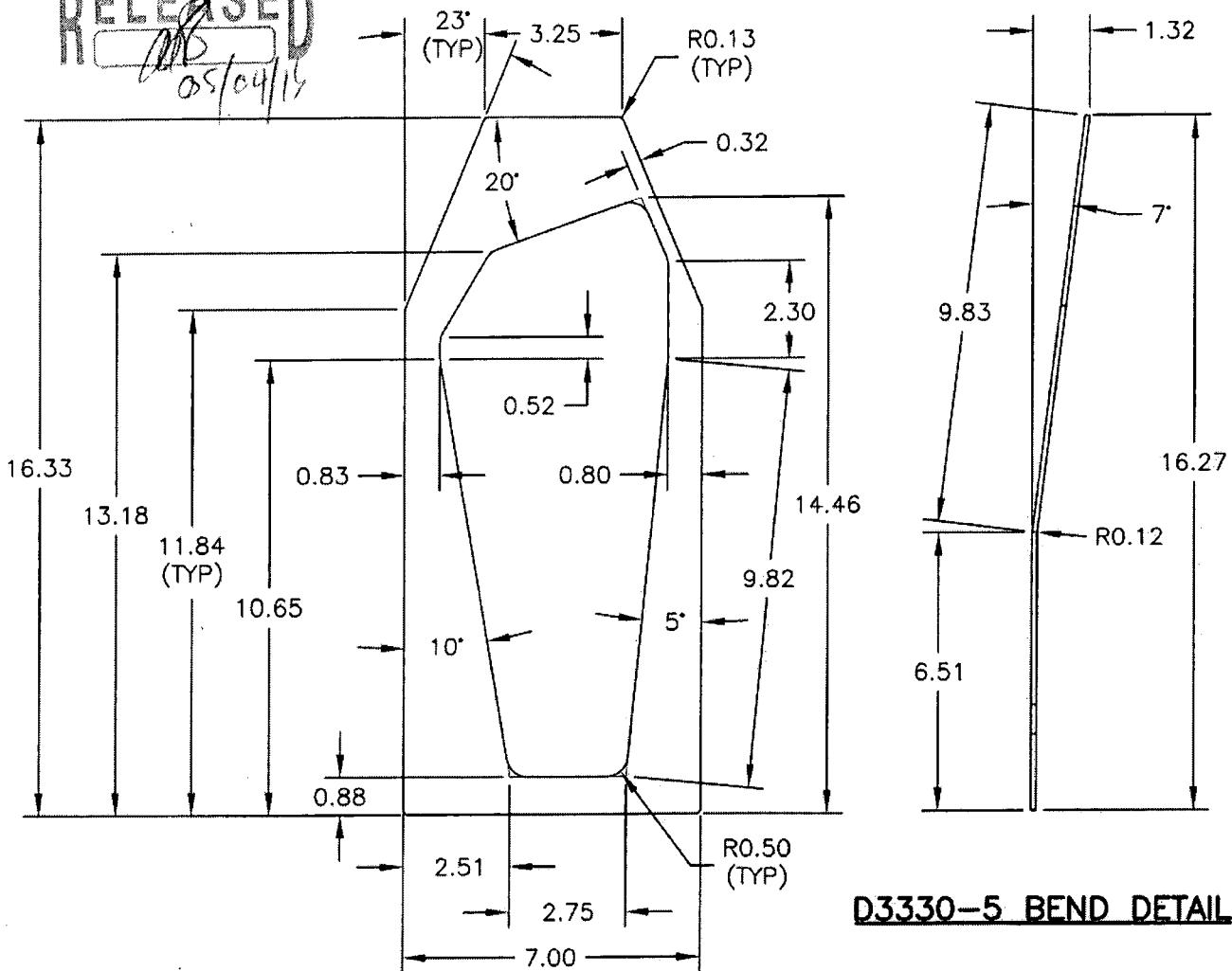
REV. B

SHEET 5 OF 9

SCALE

1:4

RELEASED
MD
05/04/16



FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 CONTROLLED COPY
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK) AMENDMENT SUBJECT TO
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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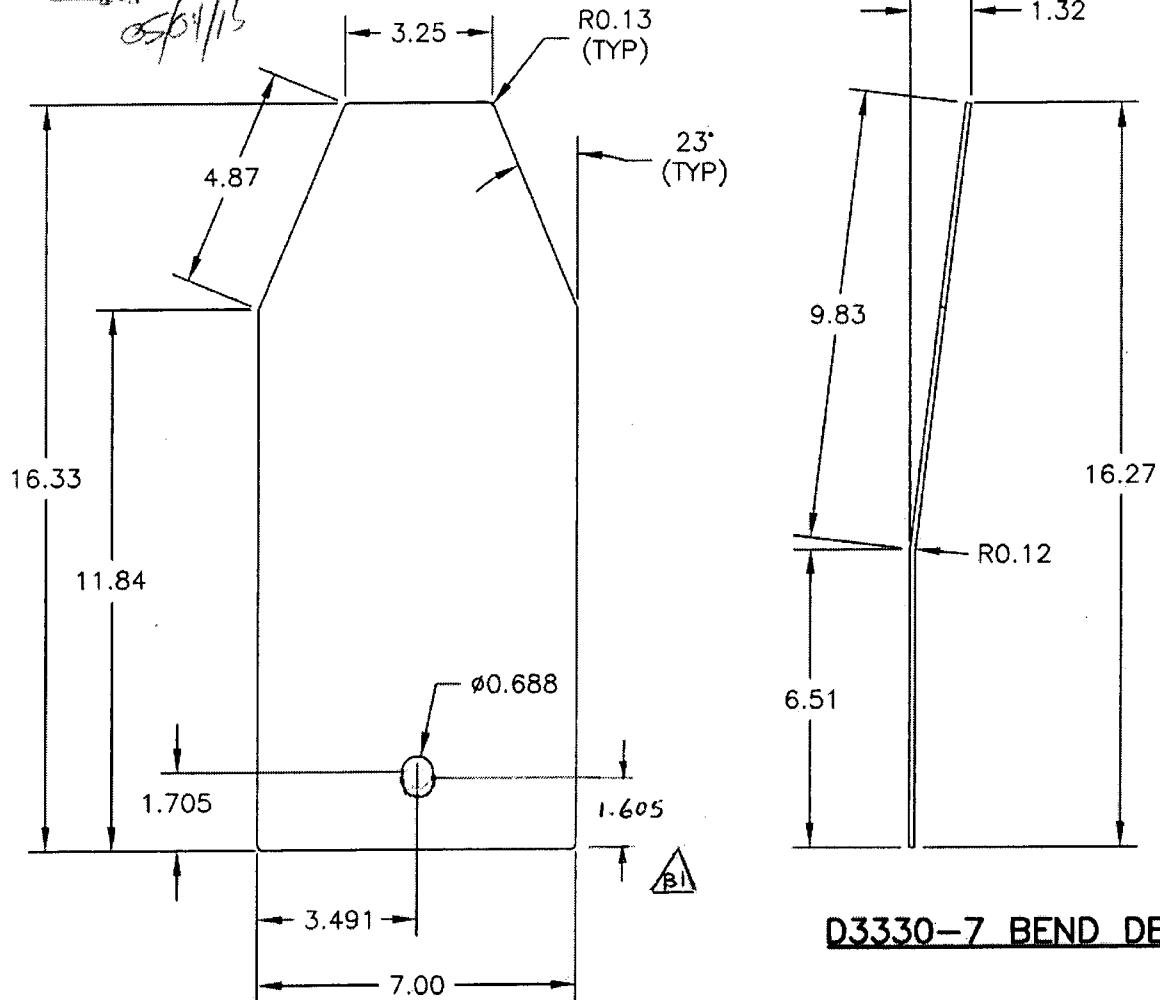


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SCALE

1:4

RELEASED
05/01/15



D3330-7 BEND DETAIL

FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, RETURN TO 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICKNESS)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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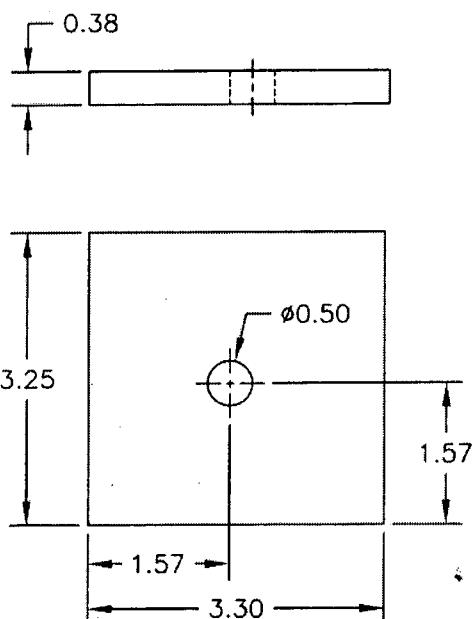
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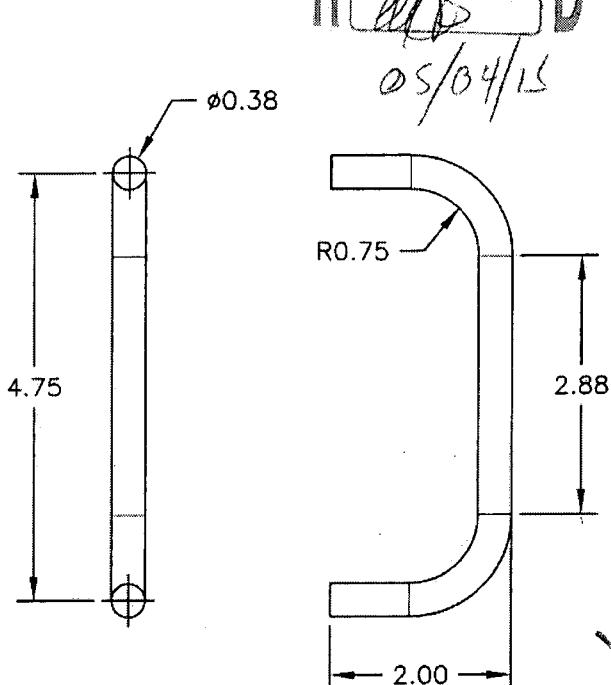
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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:2



△ D3330-9 TOP PLATE



△ D3330-15 HANDLE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

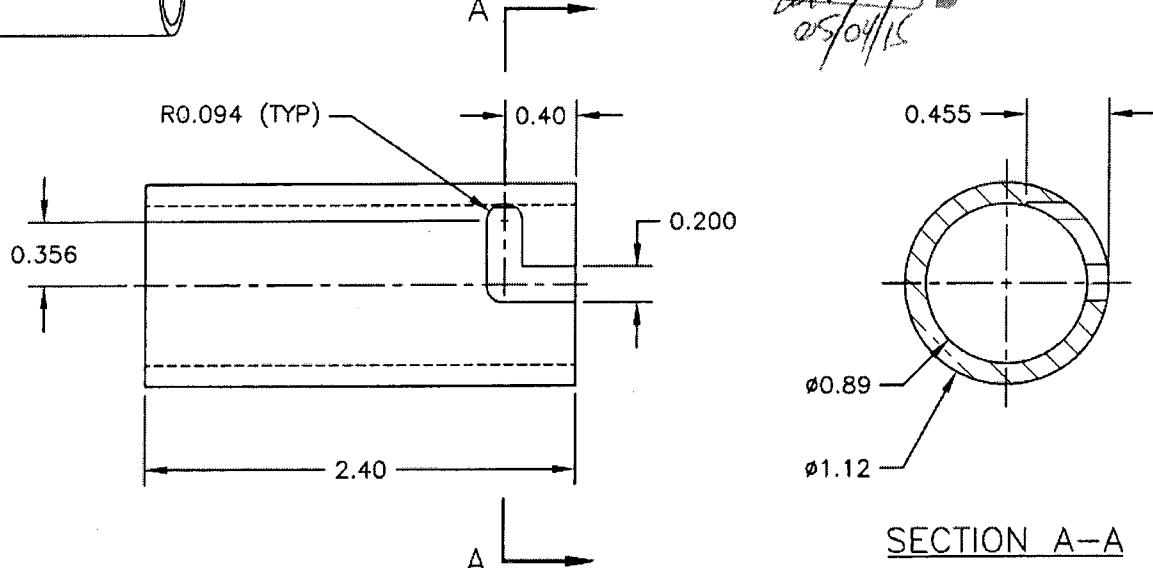
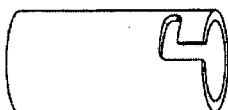
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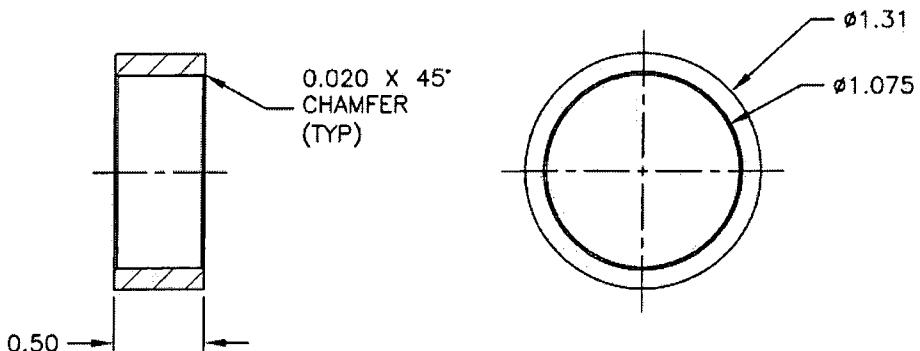
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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:1



D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

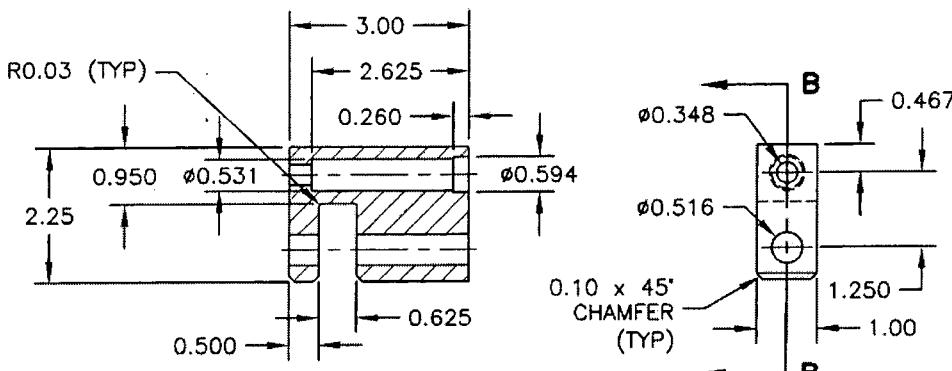
NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097
(REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

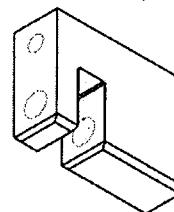
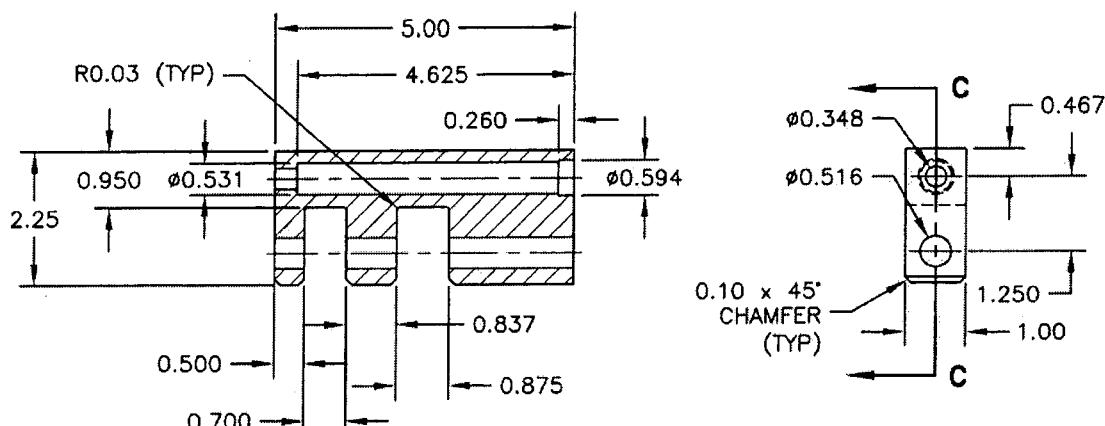
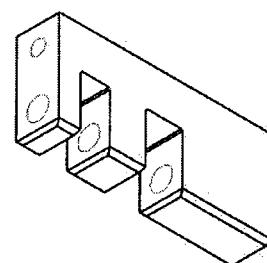
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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:3

**SECTION B-B**

RELEASED
[Handwritten signatures and notes: APP, 05/04/15.]

**D3330-13 SHORT PIN BRACKET****SECTION C-C****D3330-11 LONG PIN BRACKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEELLED COPY
(REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
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